

ABSTRACT

A mold for injection molding which is comprised of a mold cavity having an inside shape fit to an outside shape of a target product and a temporary space being communicated with the mold cavity and is eliminated before an amount of a molten material being injected to the mold cavity reaches the capacity of the mold cavity.

Said mold cavity has two or more gates that can be controlled of start of injection respectively, and, said temporary space is a ditch 126 which has an eliminator to eliminate itself and is set on the surface of the mold cavity where it connects opening portions of the two gates 111 and 112 that are mutually adjacent, and, the second gate 112 is set to be opened after a melt-front of a molten resin injected from the first gate 111 reaches the position of said second gate 112, a molten resin being progressed in the ditch 126 is pushed and returned to the mold cavity by using the eliminator, and, said eliminator is started when a melt-front of a molten resin from said first gate 111 reaches the position of said second gate 112.

